

Work Order ID 125431***125431***

Page 1

Tuesday, October 07, 2014 10:43:44 AM

Item ID: D3836-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Rib Assembly (Basket Lid, LH)

Start Date: 10/06/14 Start Qty: 2.00 ***2***

Cust Item ID:

Required Date: 10/06/14 Req'd Qty: 2.00 ***2***

Customer:

Reference:

Approvals: Process Plan: WLS Date: 14-10-09 Tooling: _____ Date: _____Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D3836	C
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100

0.00

100

Large Fab

Large Fab

Memo

0.00

Large Fab

1- cut D3836-1 and D3836-3 rib as per dwg D3836. USE DT9827 TO TRACE D3836-3

2- remove identification markings

3- deburr

4- weld D3836-1 to D3836-3 and drill hole (3/16") using DT9447 jig and open to finish size as per dwg D3836

5- c'sink holes for D4021-9-1 bushing

6- weld D2327-3 spacer bushing and bushings D4021-9 as per dwg D3836
A/R ER316 S.S. Rod Batch: B125054

7- grind weld flush where indicated on dwg

CC 15-1-262X DL 15/11/22

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Crosstube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 125431***125431***

Page 3

Tuesday, October 07, 2014 10:43:44 AM

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Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Rib Assembly (Basket Lid, LH)

Start Date: 10/06/14 Start Qty: 2.00

2

Cust Item ID:

Required Date: 10/06/14 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

15/1/28

15.1-27

DQA: _____ Date: _____



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Picklist Print

Tuesday, October 07, 2014 10:43:44 AM

Page 1

Work Order ID: 125431

125431

Parent Item: D3836-041

D3836-041

Parent Item Name: Rib Assembly (Basket Lid, LH)

Start Date: 10/06/14

Required Date: 10/06/14

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 08-12-01 new issue DD verified by:EC IPP REV:B
12.07.24 AS PER REV.B DD VERF:EC IPP REV:C 12.08.08
AS PER DWG REV.C DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2327-3		Manufactured	No			100	Each	62.0000	1	2			
D2327-3									**				
Spacer Bushing													

Location

Loc Qty

Loc Code

WA004

62

100523

27

103679

35

D4021-9		Manufactured	No			100	Each	266.0000	2				
D4021-9									**				
Bushing													

Location

Loc Qty

Loc Code

WA004

266

107634

2

116010

60

116663

64

117495

1

120334

40

121536

20

121805

21

122601

20

123427

38

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐
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Picklist Print

Tuesday, October 07, 2014 10:43:44 AM

Page 2

Work Order ID: 125431

125431

Parent Item: D3836-041

D3836-041

Parent Item Name: Rib Assembly (Basket Lid, LH)

Start Date: 10/06/14

Required Date: 10/06/14

Start Qty: 2.00

Required Qty: 2.00

M304TS0.750W.065

Purchased

No

100 f

1,514.415 1.7808 4

M304TS0 750W 065

304 SQ Tube .75x.75x.065W

OK 15/1/22

Location

Loc Qty

Loc Code

WA004

1514.415

~~125513~~

446.015

m126538

362

m126922

106.4

m128495

600

4

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

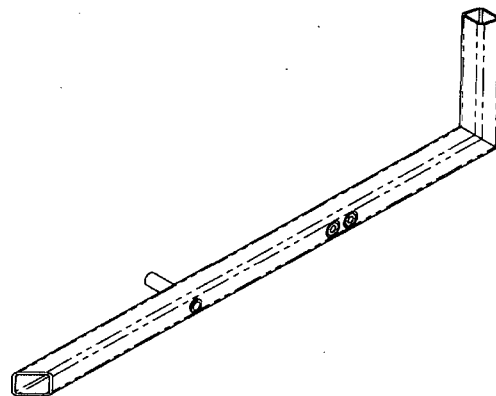
Work Order update only ☐

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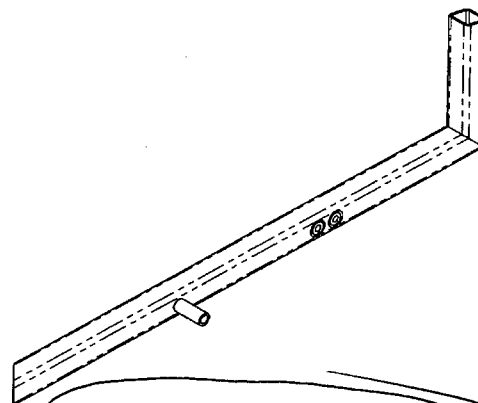
Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
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Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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D3836-042 RIB ASSY (BASKET LID, RH)



D3836-041 RIB ASSY (BASKET LID, LH)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.02 lbs EACH
- 8) WELD PER DART QSI 004

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
	X		D3836-041	RIB ASSY (BASKET LID, LH)
		X	D3836-042	RIB ASSY (BASKET LID, RH)
1	1	1	D2327-3	SPACER BUSHING
2	1		D3836-1	RIB
3		1	D3836-2	RIB
4	1	1	D3836-3	RIB
5	2	2	D4021-9	BUSHING

SHOP COPY
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO 125431 M15
1410-09

RELEASED
2012-08-03
WMP

C	D4021-9 WAS D3759-1 (ZN D3-1) AND 11.05 WAS 11.673 (ZN B7-3 & CT-3). REASON FOR CHG: AN3 SIZE BOLTS REQ'D IN THOSE LOCATIONS AND CORRECTED DIM IAW FIG 9a OF D350-807-1 REV. A.	MB	12.07.18
B	ADD QTY(2) D3759-1 BUSHING TO D3836-041/-042 (ZN D3-1, C8-2, C3-2, C6-3, C5-3, B6-3, B5-3). REASON: PART 10-50.	MB	12.05.11
A	NEW ISSUE	MB	08.09.24
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>[Signature]</i>		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D3836	SHEET 1 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	RIB ASSY (BASKET LID)	NTS
DATE	12.07.18	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND PROPRIETARY AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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8

7

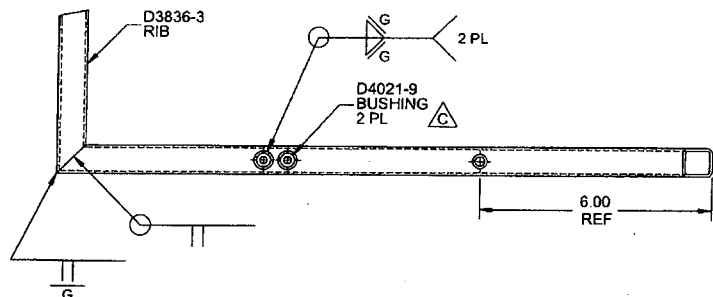
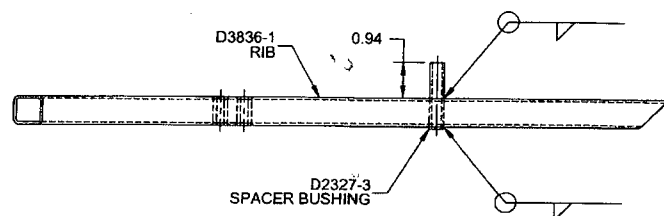
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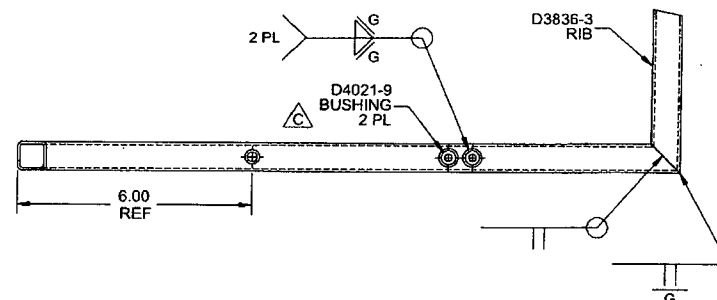
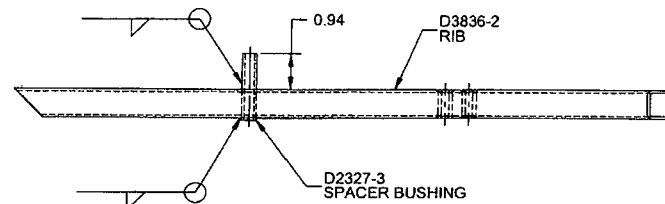
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3

2



D3836-041 RIB ASSY (BASKET LID, LH)



D3836-042 RIB ASSY (BASKET LID, RH)

RELEASED
2012-08-03

DESIGN	5	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	A.P.	DRAWING NO.	REV. C
MFG. APPR.		D3836	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		RIB ASSY (BASKET LID)	NTS
DATE	12.07.18	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

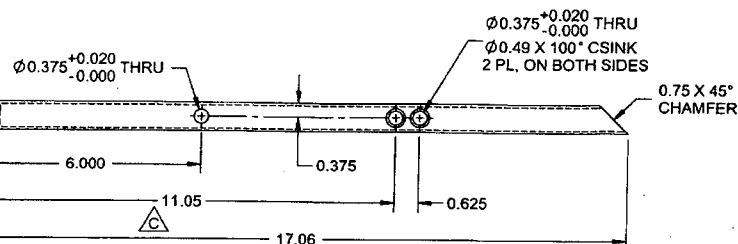
Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

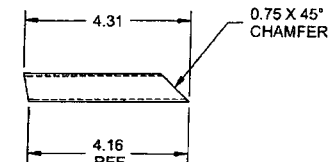
FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off set ☐ Out of Calibration ☐ Out of Sequence
		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
		☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other

0.75 X 45°
CHAMFER

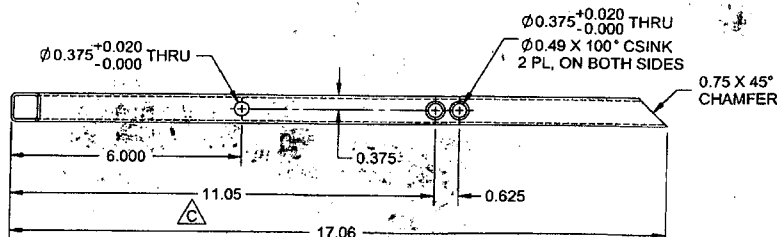


D3836-1 RIB

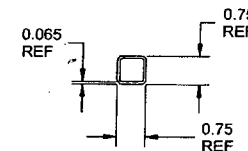


D3836-3 RIB

0.75 X 45°
CHAMFER



D3836-2 RIB



**TYPICAL SECTION
VIEW**

RELEASED
2012-08-03

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3836-1/-2 = 0.77 lbs EACH; D3836-3 = 0.19 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	A.P.	DRAWING NO.	REV. C
MFG. APPR.		D3836	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		RIB ASSY (BASKET LID)	NTS
DATE	12-07-18	COPYRIGHT © 2008 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE REPRODUCED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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WORK ORDER NON-CONFORMANCE / UPDATE

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Training									
Transport									
Unapproved									

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